

Work Order ID 52580



Page 1

October 2, 2009 9:16:54 AM

Item ID: D2003-025

Accept



Setup Start



Revision ID: U/R

09/10/02 D-REQ

Stop



Item Name: Tube Assembly-8D

B 54776

Start Date: 02/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *PP*

Date: 09-10-2

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2003

Rev U/R

09/10/02

100

0.00



Small Fab

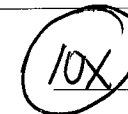
Small Fab

Memo

Form tube as per template D2003-025

0.00

7m. 09/11/05



110

QC5- Inspect part completeness to step on W/O

0.00



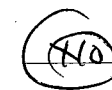
QC

Memo

Quality Control

0.00

27 09/11/05



Work Order ID 52580

October 2, 2009 9:16:54 AM



Page 2

Item ID: D2003-025
 Revision ID: U/R *09.10.02*
 Item Name: Tube Assembly-8D

Accept



Setup Start



Stop



Start Date: 02/10/2009 Start Qty: 10.00
 Required Date: 12/10/2009 Req'd Qty: 10.00



Cust Item ID:
 Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Cut tube as per Dwg D2003								
	2-Cut Heat sleeve as per Dwg D2003.								
	3-Install Red decal and heat shrink								
	4-Assemble as per Dwg D2003								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140 	Identify as per dwg & Stock Location: <u>192</u>	0.00							
Packaging	Memo	0.00							
Packaging									

* CONFIRM CUT LENGTHS OF TUBE AND HEAT SLEEVES WITH DWG. PRIOR TO INSPECTION.
09.10.02 → CUT LENGTH VERIFIED, DWG OF *09.11.05*

→ *09.12.18*

(HIO)

09/14/21 *(10)*

Work Order ID 52580



Page 3

October 2, 2009 9:16:54 AM

Item ID: D2003-025

Accept



Setup Start



Revision ID: U/R

09.10.02

Stop



Item Name: Tube Assembly-8D

Start Date: 02/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21 *[Signature]*

09/12/21

Picklist Print

Page 1

October 2, 2009 9:16:53 AM

Work Order ID: 52580

Parent Item: D2003-025RevU/R

Parent Item Name: Tube Assembly-8D

Comments:


Start Date: 02/10/2009

Required Date: 12/10/2009

Start Qty: 10.00

Required Qty: 10.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN818-8D		Purchased	No				Each	40.0000	20.0000			
												
Nut												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	40	
	103154	10	
	112492	30	

M-L 09/11/17


20X

M6061T6T0.500W.035		Purchased	No				f	488.6538	9.2979			
												
6061-T6 RD Tube .500 x.035W												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	MAT	488.6538	
	4692 ✓	488.6538	
Main Warehouse	ST	-0.00004211	
	4692	-4.211E-05	

M-L 09/11/05

M4692

MS20819-8D		Purchased	No				Each	52.0000	20.0000			
												
Sleeve												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	52	
	101840	2	
	112612	50	

M-L 09/11/17

2

B

09/11/19

M2650-G

Qty .816 Feet

Batch: M112195

D2182 - 025

M107834

B218045 M3999

20X



DESIGN A	DRAWN BY SP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JE	APPROVED A	DRAWING NO. D2003	REV. B SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS
A	90.04.09	NEW ISSUE	
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
44-06-08 KE

~~UNDER REVIEW~~

CC.08.21 CB

some flat
lengths wrong

400, 10.02

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											UNCONTROLLED COPY	
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											WITHOUT NOTICE	
											WORK ORDER	
											NO. <u>52580</u>	
											<u>09-10-2</u>	
P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/8/7}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.1	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2003	REV. B SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	

RELEASED
99.06.08 KE

UNDER REVIEW

06.08 21 CB

Some flat lengths
not wrong

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (VV-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. 32580

BS 09-10-2

